

Work Order ID 85522

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85522

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Item ID: D412-709-023

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Hinge Panel Door Replacement Push-Out Window

Stop

NS2

Start Date: 08/06/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 22/06/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/08 Tooling:

Date:

Run Start

NR1

QC:

Date: SPC (Y/N):

Date:

Stop

NR2

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr | | | | | | | | |
|----------|--------------|--|--|--|--|--|--|--|--|
|----------|--------------|--|--|--|--|--|--|--|--|

| | | | | | | | | | |
|-----|-------|--|--|--|--|--|--|--|--|
| N/A | Rev C | | | | | | | | |
|-----|-------|--|--|--|--|--|--|--|--|

100

100

DC

Document Control

DOCUMENT CONTROL

Memo

0.00

110

110

Packaging

Packaging

Pick Kit

0.00

120

120

QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

Memo

0.00

5/7/08/20

2

12/06/19/23

Q1

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Item ID: D412-709-023

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Hinge Panel Door Replacement Push-Out Window

Stop

NS2

Start Date: 08/06/2012 Start Qty: 2.00 *2*

Cust Item ID:

Required Date: 22/06/2012 Req'd Qty: 2.00 *2*

Customer:

Reference:

| | | | | | | | |
|------------|---------------|-------|------------|-------|-----|-------|-------|
| Approvals: | Process Plan: | Date: | Tooling: | Date: | Run | Start | *NR1* |
| | QC: | Date: | SPC (Y/N): | Date: | | Stop | *NR2* |

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|----------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130 *130* Packaging | Packaging | 0.00 | R9A | | | | | | 12/6/20 ② |
| | Memo | 0.00 | | | | | | | |
| | Identify and pack for shipping as per PPP D412-709-021 | | | | | | | | |
| | Identify and StockLocation: <i>RWA</i> | | | | | | | | |
| 140 *140* QC | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | 12/6/20 ④ |
| | Memo | 0.00 | | | | | | | |
| | Quality Control | | | | | | | | |

12/6/20 ④
12/6/20 ④

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

| Work Order: _____ Part No. _____ NCR No. _____ | | | | DISPOSITION | | AGAINST DEPARTMENT/PROCESS | | | | | | |
|--|---|--------------------------------------|--|---|--|--|--|--|-------------|--------------|--------------|--|
| | | | | <input type="checkbox"/> Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update | <input type="checkbox"/> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab | <input type="checkbox"/> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite | <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> Other | <input type="checkbox"/> Engineering <input type="checkbox"/> Quality | | | | |
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | | Initial Chief Eng | Action Description | | Sign & Date | Verification | QC Inspector | |
| Doc/Data | | | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | | | |
| Operator | | | | | | | | | | | | |
| Material | | | | | | | | | | | | |
| Offset/Setup | | | | | | | | | | | | |
| Other | | | | | | | | | | | | |
| Process | | | | | | | | | | | | |
| Supplier | | | | | | | | | | | | |
| Training | | | | | | | | | | | | |
| Unauthorized | | | | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | | | | |
| Landing Gear | Hardware | | | General | | | | | | | | |
| | <input type="checkbox"/> Bending Passes Below Min | <input type="checkbox"/> Breaking | <input type="checkbox"/> Burrs | <input type="checkbox"/> Maintenance | <input type="checkbox"/> Set-up | | | | | | | |
| | <input type="checkbox"/> Centre Not Concentric to O/S | <input type="checkbox"/> Missing | <input type="checkbox"/> Contamination | <input type="checkbox"/> Mislabeled | <input type="checkbox"/> Supplier | | | | | | | |
| | <input type="checkbox"/> Cracks | <input type="checkbox"/> Size/Length | <input type="checkbox"/> Cut Too Short | <input type="checkbox"/> Off-Set | <input type="checkbox"/> Temperature/Cure | | | | | | | |
| | <input type="checkbox"/> Crushed/Crimp at Bending | <input type="checkbox"/> Spinning | <input type="checkbox"/> Documentation/Data | <input type="checkbox"/> Orientation Misread | <input type="checkbox"/> Weld | | | | | | | |
| | <input type="checkbox"/> Inspection Strip in Tube | <input type="checkbox"/> Threading | <input type="checkbox"/> Finish | <input type="checkbox"/> Out of Calibration | <input type="checkbox"/> Wrong Stock Pulled | | | | | | | |
| | <input type="checkbox"/> Other | <input type="checkbox"/> Wrong | <input type="checkbox"/> Inspection Incomplete | <input type="checkbox"/> Out of Sequence | <input type="checkbox"/> Other | | | | | | | |
| | <input type="checkbox"/> Positioned Wrong | | <input type="checkbox"/> Inspection Unqualified | <input type="checkbox"/> Outside Dimensions | | | | | | | | |
| | <input type="checkbox"/> Ripples on Inner Bend | | <input type="checkbox"/> Instructions Incomplete/Unclear | <input type="checkbox"/> Over/Under tolerance | | | | | | | | |
| | <input type="checkbox"/> Torque Waves in Extrusion | | <input type="checkbox"/> Jigs/Fixtures/Tooling | <input type="checkbox"/> Part Lost | | | | | | | | |
| | <input type="checkbox"/> Turning Sequence | | <input type="checkbox"/> Kit Incorrect | <input type="checkbox"/> Part Moved | | | | | | | | |
| | <input type="checkbox"/> Wave/Twist in Tube | | <input type="checkbox"/> Kit Missing | <input type="checkbox"/> Raw Material | | | | | | | | |

Picklist Print

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Work Order ID: 85522

85522

Parent Item: D412-709-023

D412-709-023

Parent Item Name: Hinge Panel Door Replacement Push-Out Window

Start Date: 08/06/2012

Required Date: 22/06/2012

Start Qty: 2.00

Required Qty: 2.00

5.0 PARTS LIST

| Qty -011 | Qty -013 | Qty -015 | Qty -017 | Qty -019 | Qty -021 | Qty -023 | Part Number | Description |
|-------------|-------------|-------------|-------------|-------------|-------------|-------------|--------------|---|
| X | | | | | | | D412-709-011 | ESCAPE PANEL MODIFICATION KIT |
| 1 | X | | | | | | D412-709-013 | ESCAPE PANEL PUSH OUT WINDOW KIT |
| | X | | | | | | D412-709-015 | HINGE PANEL DOOR MODIFICATION KIT |
| | 1 | X | | | | | D412-709-017 | HINGE PANEL DOOR REPLACEMENT WINDOW KIT |
| | | | X | | | | D412-709-019 | CARGO DOOR PUSH OUT WINDOW KIT |
| | | | | X | | | D412-709-021 | HINGE PANEL DOOR PUSH OUT WINDOW MODIFICATION KIT |
| | | | | | 1 | X | D412-709-023 | HINGE PANEL DOOR REPLACEMENT PUSH OUT WINDOW KIT |
| | | | | | | | D2126-0720 | LOCKING SEAL |
| 1 | | | | | | | D3118-3 | SIGN ASSEMBLY |
| | | | | 1 | | | D3136-041 | WINDOW ASSEMBLY |
| | 1 | | | | | | D3136-043 | WINDOW ASSEMBLY |
| 1 | | | | | | | D3224-1 | FRAME |
| | | | 1 | | | | D3236-1 | WINDOW |
| | | | | | | 1 | D3237-1-0720 | SEAL RETAINER |
| | 1 | | | 1 | | | D3237-1-0980 | SEAL RETAINER |
| | | | | | | 1 | D3237-3-0720 | SEAL FILLER |
| | 1 | | | 1 | | | D3237-3-0980 | SEAL FILLER |
| 2 | | | | | | | D3239-1 | COVER |
| | 1 | | | | | | D3240-1 | FRAME |
| | | | | | | 1 | D3543-1 | HINGE PANEL DOOR PUSH OUT WINDOW |
| | | | | | | 1 | D3543-3 | HINGE PANEL DOOR PUSH OUT WINDOW FRAME |
| | 1 | | | 1 | | 1 | D3561-1 | WINDOW SEAL TOOL |
| 3 | | | | | | | AN6-20A | BOLT |
| 2 | | | | | | | AN960JD10L | WASHER |
| 5 | | | | | | | AN960JD616 | WASHER |
| 5 | | | | | | | AN960JD616L | WASHER |
| 2 | | | | | | | MS21042L3 | NUT |
| 3 | | | | | | | MS21042L6 | NUT |
| 2 | | | | | | | MS35207-262 | SCREW |